

42

Date: Tuesday, 10/2/2007 10:39:43 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD MOUNTING LUG  
 Job Number : 34934  
 Estimate Number : 10453  
 P.O. Number :  
 This Issue : 10/2/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D26162  
 Drawing Number : D2616 REV D3  
 Project Number : N/A  
 First Issue : / / Type : MACHINED PARTS Drawing Revision : D3  
 Material :  
 Previous Run : 27886 Due Date : 10/15/2007 Qty: <sup>10</sup>/<sub>20</sub> Um: Each  
 Written By :  
 Checked & Approved By : 07.10.02  
 Comment : Est Rev: C 00.06.22 Removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.1749 f(s)/Unit Total: 3.4986 f(s)  
 Material: 6061-T6 QQ-A-200/8 2" X 1" Bar  
 Batch M106563

mf 08/02/02

10

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks: 2.000" long +0.030" -0.000"

mf 08/02/02

10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2616-2 & DWG D2616

2-Tumble & Deburr

J.L 08/02/11

PTO →

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/02/11

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 08.02.11

(10)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: DZ616-2 PAR #: N/A Fault Category: Prod / Machine NCR: (Yes) No DQA: JD Date: 08/03/06  
 QA: N/C Closed: JA Date: 08/03/06

NCR: 34934		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/10	3	- 2 part Ø.8115 -812 <del>are</del> are being opened at .8135 by .811 reamer	<u>JS/ML</u>	- scrap + replace (Qty 82) B# 106563	J.L 08/02/10	<u>JS/ML</u>	<u>JS/ML</u>	<u>JS/ML</u>

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:39:43 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 34934

Part Number: D26162

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-02-12

(10)

7.0

POWDER COATING

POWDER COATING



M106442



(10X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Mask large hole

m-l 08/02/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-13

(X10)

9.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2611

Bearing

1536029 (10X)

B 37888 (10X) 50

8/2/14

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Coat bearing in light oil

2-Press Bearing in D2616-2

3-Stack as per Dwg D2616 using DT8019

4- Touch up paint if required

X10  
ml 09/03/03

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/03 (X10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 468

5/3/13 36 (10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/2/2007 10:39:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 34934

Part Number: D26162

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*2008/3/04*

*10*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 34934
<b>Description:</b> Mounting Lug		<b>Part Number:</b> D2616-2
<b>Inspection Dwg:</b> D2616 <b>Rev:</b> D3		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.250	✓			
1.250	+/-0.010	1.249	✓			
0.375	+/-0.010	.375	✓			
0.625	+/-0.010	.626	✓			
Ø0.257	+0.006/-0.001	.258	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	1.998	✓			
1.125	+/-0.010	1.126	✓			
0.313	+/-0.010	.314	✓			
17°	+/-0.5°	17°	✓			
1.259	+/-0.010	1.259	✓			
Ø0.625	+0.008/-0.001					N/A 7/10/08 .02.11
R0.250	+/-0.010	.250	✓			
R0.063	+/-0.010	.063	✓			
Ø0.8115- Ø0.8120	N/A	.8115	✓			

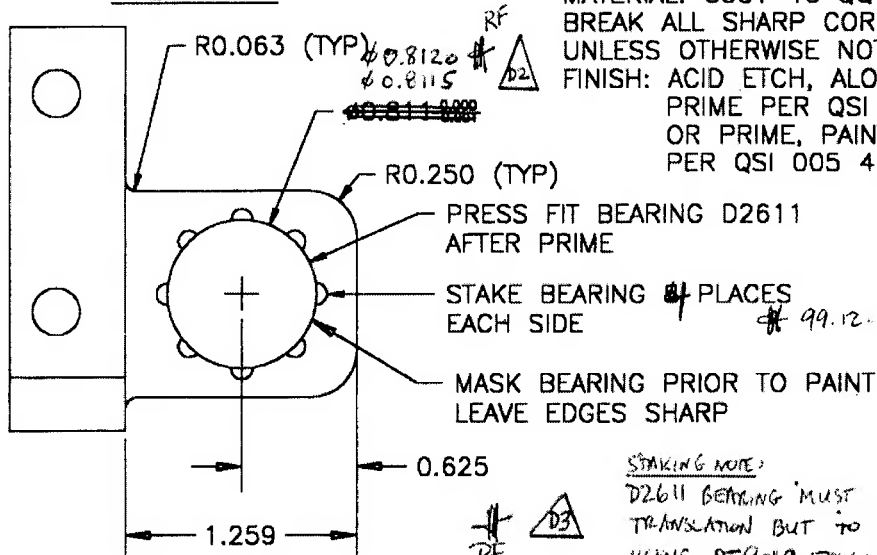
<b>Measured by:</b> J.L	<b>Audited by:</b> J.F	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/02/10	<b>Date:</b> 08/02/10	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	



DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>BW</i>	DRAWING NO. D2616	REV. D SHEET 1 OF 1
DATE 97.07.31		TITLE FWD MOUNT LUG	SCALE 1:1
D1	99.12.16	STAKE 4 PLS INSTEAD OF 8 PLS/SIDE	A
D2	00.11.21	CHG. HOLE TOL. PER NCR 449.	B
D3	02.04.30	ADD STAKING NOTE PER CAR 107	C
D	97.07.31	D2611 WAS CBA-6-B2	

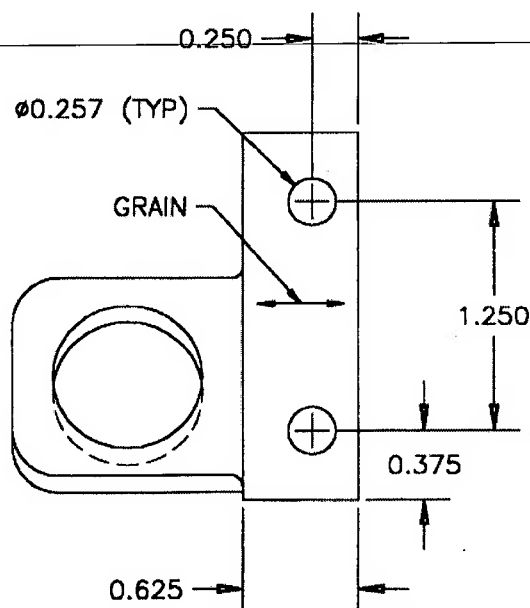
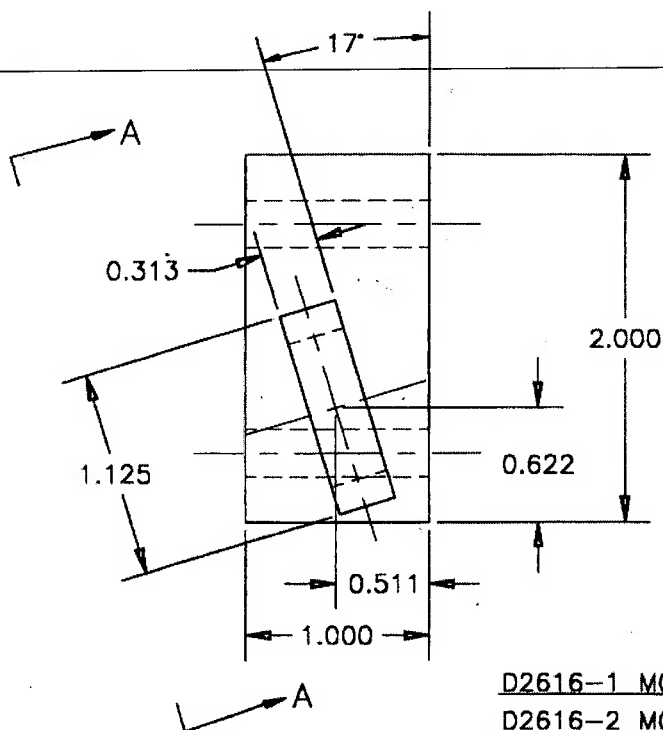
### VIEW A-A



MATERIAL: 6061-T6 QQ-A-200/8  
BREAK ALL SHARP CORNERS 0.010 TO 0.020  
UNLESS OTHERWISE NOTED  
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1  
PRIME PER QSI 005 4.2  
OR PRIME, PAINT PER CUSTOMER SPEC  
PER QSI 005 4.2

RELEASED  
97.07.31 BW

STAKING NOTE:  
D2611 BEARING MUST BE STAKED TO PREVENT  
TRANSLATION BUT TO STILL ALLOW ROTATION  
USING DT8019, TOUCH UP PAINT AFTER STAKING.



D2616-1 MOUNTING LUG SHOWN  
D2616-2 MOUNTING LUG OPPOSITE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34934



